Work Order ID 99670 April-11-13 2:39:31 PM				*996 ₇ 70*							Page 1		
Item ID: Revision ID:	D4072-3	: : : : : : : : : : : : : : : : : : :		Accept	*N900	040	100)* s	Setup Start	*N:	S1*	-	
Item Name:	Airframe I	linge Backing Plate							Stop	*N:	S2*		
Start Date: Required Date: Reference:	4/08/13	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item I Customer:	ID:							
Approvals:		Plan: MC5	- •	•		ate:		ſ	Run Start Stop	. 171	R1* R2*		
Sequence ID/ Work Center II	 D	Operation Description	 	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	 1	
Draw Nbr	J	Revision Nbr		,					-				
D4072	I	B											
100			-	0.00									
100 Waterjet		Memo		0.00				20	O		Ae 13,	08.07	
GOGI. 063		l-Cut as po Dwg Rev:_ Prog Rev:_	B										
		2-Deburr il	fnecessary							•			
110		QC2- Inspect parts off i	machine FAI/FAIB	0.00					:		,		
*11 0 *		Мето		0.00				_20	_ي_		13:08	. 07	

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-	cor	VFORI\	MANCE / UPD	ATE		•		-	
												QA Closed:	Date	e:_	
Morle Ord	 -					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Work Order: Part No. NCR No.				Scrap Machining Small Fall Use-as-is Thermoforming Finishing			Crosstube Small Fab Finishing Composite	b Prod. Eng. Coor. Rec/Store/Packaging				Engineering Quality Other			
Root					Descri	ption of work order update		nitial	Acti	on		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descri	iption		Date	Verification		QC Inspector
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Equip/Taoling															
Operator							1								÷
Material		٠									ı			ļ	- à
Setup	П		1					,			Į				
Other			1					*							
Process						b								i^*	
Supplier															
Training			1								ļ				
Unapproved			<u> </u>				<u> </u>]				
						F	AUI	T CATE	GORY						
Land	ing (5ear			_	General		-		_	_		r		
	L	Bending				Bend		Grain		_	_	Ovalized	ļ		Pressure/Forced
	L	Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa		<u>'</u> _	$\overline{}$	Over/Under	-		Temperature/Cure
		Cracks			L	Broken/Damaged		4 '	on Incomplete	_	-	Part Incorre	.		Weld
		Crushed/	Crimped.		L	Burrs	_	Instruct	ions Incomplete/L	Inclear	-	Part Lost/M	issing [Wrong Stock Pulled
}		Cuffs				Contamination		Mainte	nance		_	Part Moved			
1	Heat Treat			Countersink		Mislabeled				Positioned V	Vrong				

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

DQA:

Power Loss/Surge

Other

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

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1

4pril-11-13 2:3			^99670									Page
Item ID: Revision ID: Item Name:	D4072-3 Airframe Hin	P 4 0 7 2 - 3 ge Backing Plate		Accept	*N900	040	100)*	Setup	Start Stop	1 33	S1* S2*
Start Date: Required Date: Reference:	4/08/13 : 4/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:						
Approvals:		an: Date	:	Tooling: SPC (Y/N):	T	ate:	. – –		Run	Start Stop	17	R1* R2*
Sequence ID/ Work Center I. 120 *120 *120 COMPANY *120 Quality Control 130 *120 Hand Finishing	D	Operation Description QC8- Inspect parts - second check Memo Chemical Conversion Coat per QS		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty 20	Qt	·	Reject Number	Insp. Stamp
*140 *140* Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) per QSF Memo POWDER COAT: 3 Start Time: Oven Temperature: Finish Time:	005 4.3-Alum <i>つ 2</i> ン -	0.00 0.00	·		á	Zux	Š	M	-f 13	3/ <u>58/</u>

m126126

NCR	Yes	1	Mo

DQA: ____ Date: ____

NCR: Y	es / No				WORK ORDER NON-	CONFO	RIV	IANCE / UPD	DATE			
	_									QA Closed:	Date	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework	7 	Skid-tube Crosstube]	Water Jet	Engineering
Part No.					Scrap	1	Machining Small Fa			Pro	d. Eng. Coor.	Quality
				Use-as-is	Th	Thermoforming Finishin			Rec/Store/Packaging		Other	
NCR No.				Work Order Update		l	Large Fab	Composite]	Supplier		
					<u> </u>							
Root					ption of work order update	Initia	i i	Acti		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Descri	iption	Date	Verification	QC Inspector
Doc/Data		ŀ										
quip/Taoling												
Operator												
Material												
Setup						*5						
Other						5						1
Process						ł						
Supplier	_	1									•	
Training]										
Unapproved		<u> </u>	<u> </u>			AULT CA	TEC	CORV		1	<u> </u>	<u> </u>
					General	AUL! CA	(TEG	OKT				
ranoin L	g Gear Bending				Bend	Gra	in			Ovalized	Г	Pressure/Forced
}	Centre No	ot Conco	atric to (_/s	BOM/Route	\mathbf{H}	dwar	-0	<u> </u>	Over/Under	tolerance	Temperature/Cure
-	Cracks	ot concei	ithe to t	"	Broken/Damaged	\vdash		on Incomplete	}	Part Incorre	-	Weld
ŀ	Crushed/	Crimpod			Burrs	1		ons Incomplete/U	Inclear	Part Lost/M	<u> </u>	Wrong Stock Pulled
-	Cuffs	cimpeu			Contamination			nance		Part Moved	- La-	<u>الم</u>
 	Heat Trea	at			Countersink	 	label		<u> </u>	Positioned V		
-	Inspection		Tube		Cut Too Short	Misi			<u> </u>	Power Loss/		Other
	Ripples in			<u> </u>	Drill Holes	Offs			<u> </u>	_	<u> </u>	
}	Torque W		xtrusion	, -	Drawing	-		alibration				
<u> </u>	Turning S			-	Finish	-		equence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-11-13 2:39:31 PM

Item 1D:

D4072-3

Accept

N900040100

Setup Start

Stop

Revision ID:

Item Name:

Airframe Hinge Backing Plate

4/08/13 Start Date: Required Date: 4/11/13

Start Qty: 12.00 Req'd Qty: 12.00 *12*

Customer:

Cust Item ID:

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

Date:

Stop

Sequence ID/ Work Center ID Operation Description

OC3-Inspect Part Finish

Set Up/ Run Hours

0.00

150

QC

0.00 Memo

Date:

Quality Control

160

150

Identify as per dwg & Stock Location: 5709/ 0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

MCJ_13-08-13 MCS 13-08-12

Quality Control

SPC (Y/N): Tool ID

Date: Tool # Plan

Code

Accept Qty

Reject Qty

Run

Reject Insp. Number Stamp

201 d 11 13/08/09

20

				DQA:	Date:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

									QA Closed:	Date	5:
Work Orde	or'		Ţ.,		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	ť	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling										İ	
Operator			1								
Material			Ì								
Setup		İ									
Other											
Process											
Supplier											
Training							1				
Unapproved			<u> </u>					· · · · · · · · · · · · · · · · · · ·	<u> </u>	<u> </u>	
						AULT CAT	EGORY				
Landii	ng Gear				General				1	Г	
	Bendin	_			Bend	Grain		<u> </u>	Ovalized		Pressure/Forced
	_	Not Conce	ntric to	O/S -	BOM/Route	Hardv		ļ.—	Over/Under	⊢	Temperature/Cure
	Cracks				Broken/Damaged	$\overline{}$	tion Incomplete		Part Incorre	⊢	Weld
	_	d/Crimped			Burrs	\blacksquare	ctions Incomplete		Part Lost/M		Wrong Stock Pulled
	Cuffs	_		<u> </u>	Contamination	\vdash	tenance	-	Part Moved		
	Heat T		T l -	<u> </u>	Countersink	Mislal		<u> </u>	Positioned \ Power Loss,		Other
	_	tion Strip in	iube		Cut Too Short	Misre		<u> </u>	Thomes ross!	anige [Other
		in Bend	-	_	Drill Holes	Offset					
		Waves in		n	Drawing		Calibration				
		g Sequence		-	Finish	\blacksquare	Sequence de Dimensions				
	[wave/	Twist in Tu	ne	i	Folio	Outsid	ie mimensions				

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Status

April-11-13 2:39:31 PM

Work Order ID:

99670

Parent Item:

D4072-3

Parent Item Name:

Airframe Hinge Backing Plate

Start Date: 4/08/13

Required Date: 4/11/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

M6061T6S.063

6061-T6 .063 Sheet

IPP Rev:A 10.06.08 new issue DD verf:EC

Purchased

IPP REV:B DRAWING REV.

Comp	ponent Item	ID/
Item	Name	

CHANGE AS PER	ECN 11-598
Replacement	Mfg/
Item ID	Durch

Bin	Primary
Item	Location

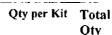
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	Location

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sure	Hand



Qty Qty

Date Issued Issued

No

100

Loc Oty

232.8625

Loc Code

0.0087

Location MAT021

11-07-05 JFS VERIFIED BY:

123135 124003 232.8625 120,5625

112.3

NCR:	Yes	/	No

WORK ORDER NON CONFORMANCE / LIDDATE

DQA: _____ Date: _____

NCR: Y	es / No				WORK ORDER NON-C	JOINFORI	VIAINCE / UPI		QA Closed:	Date	:
Work Orde	· · ·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
			· · · · · · · · · · · · · · · · · · ·		Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
Part No.				Use-as-is	↓ 	noforming	Finishing		re/Packaging	Other	
NCR N	lo.				Work Order Update		Large Fab	Composite	11.00,0101	Supplier	
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Śtep	Qty	(or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator		1									
Material							j				
Setup											
Other		1									
rocess							1				
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					F	AULT CATE	GORY				
Landir	ng Gear			_	General				1	-	- .
	Bending			<u> </u>	Bend	Grain			Ovalized	<u> </u>	Pressure/Forced
ļ	Centre N	ot Conce	ntric to O,	/s	BOM/Route	Hardwa			Over/Under	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged	├ ── ! '	ion Incomplete	<u> </u>	Part Incorre	├	Weld
	Crushed/	'Crimped			Burrs	 	tions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
ļ	Cuffs				Contamination	\vdash	enance	<u> </u>	Part Moved		
. [Heat Trea	at			Countersink	Mislabe	eled		Positioned V		_
Ĺ	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	'Surge	Other
	Ripples it	n Bend			Drill Holes	Offset					
[Torque V	Vaves in E	Extrusion		Drawing	Out of	Calibration				···
	Turning 9	Sequence			Finish	Out of	Sequence				
Ī	Wave/Tv	vist in Tul	be		Folio	Outside	e Dimensions				

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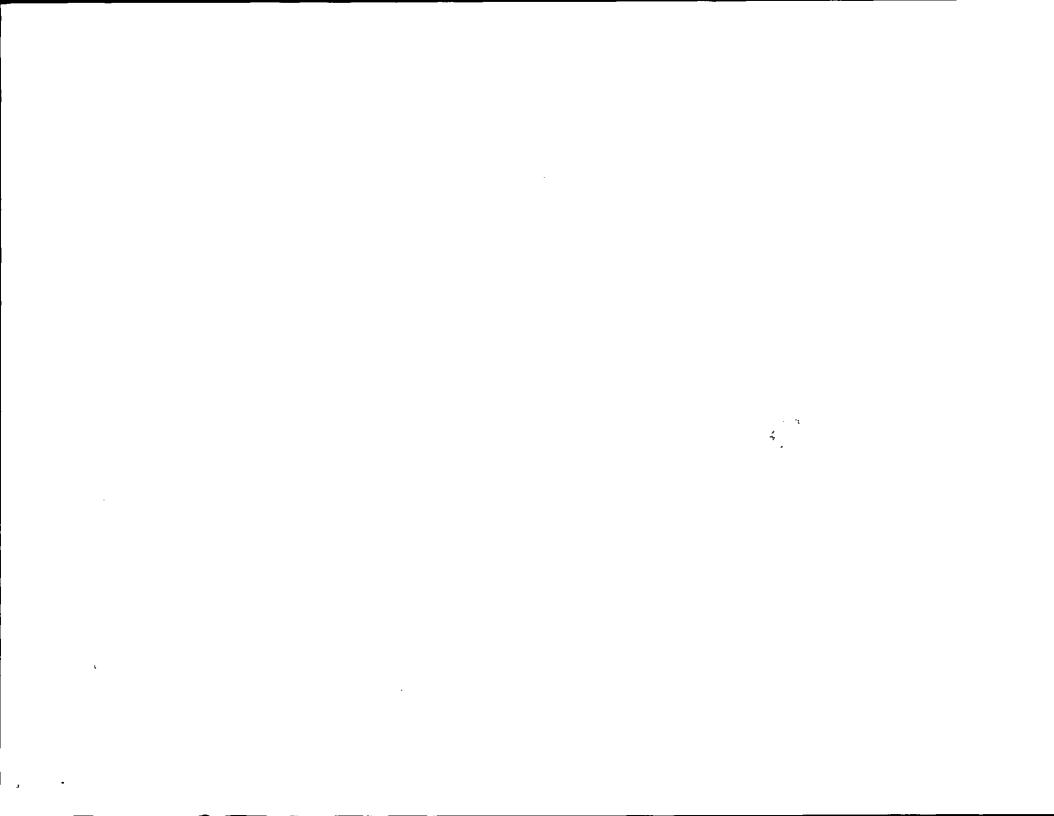
DART AEROSPACE LTD	Work Order:	99670
Description: Airframe Hinge Backing Plate	Part Number:	D4072-3
Inspection Dwg: D4072 Rev: B		Page 1 of 1

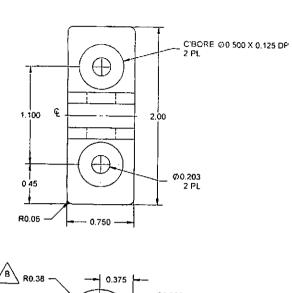
FIRST ARTICLE INSPECTION CHECKLIST

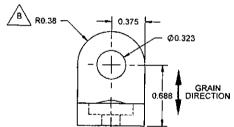
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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2.00	+/-0.010	2.00			_V	
0.63	+/-0.030	. છત્ર			V	
0.45	+/-0.030	. પુઇ	-			
0.31	+/-0.030	. 31	-		V	
1.100	+/-0.010	1,100	_		V	
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		140		
Measured by:	Audited by:	647N	Preliminary Approval:	
Date: 13.08.07	Date: 13	オフ	Date:	

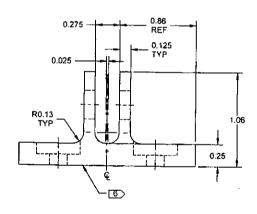
Rev	Date	Change	Revised by	Approved
Α	10.10.25	New Issue	KJ ,A.	1.1
В	11.07.26	Dwg Rev updated	KJ -KX	77
			77	····







99670 MLJ 13-04-16



RELEASE 2011 -06- 30

D4072-1 AIRFRAME HINGE

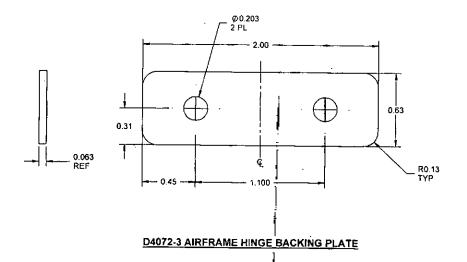
NOTES:	
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR	
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/41	16)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)	,,,
OR ASTM B211 OR ASTM B221	
REF DART SPEC M6061T6B	
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1	
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3	
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	
4) UNITS: INCHES UNLESS OTHERWISE NOTED	
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX	
6) IDENTIFICATION: PER QSI 044 6.1	
7) WEIGHT: 0.04 lbs	

В	CORREC	CORRECT TYPO (ZN 87-1)			
Α	NEW ISSU	JE	-	RF	10.09.16
REV.	T		DESCRIPTION	BY	DATE
DESIG DRAW		RE	DART AEROSPAC	E USA	, INC.
CHECK MFG. A		1	DRAWING NO. D4072	·	REV. B
APPRO DE API			AIRFRAME HINGE		SCALE NTS
DATE 10.11.02			COPYRIGHT © 2010 BY DART AI THE DOCUMENT'S PRINCE WAS COPYRIGHT AND COPY	EN ON THE YEARS.	LOCKDINGS Refut &

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NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

С

В

DESIGN	6	DART AEROSPACE USA, INC.		
DRAWN	RF.			
CHECKED	#	DRAWING NO.	REV. B	
MFG. APPR.	94	D4072	SHEET 2 OF 3	
APPROVED	-	TITLE	SCALE	
DE APPR.	-#	AIRFRAME HINGE	итѕ	
DATE 10.	11.02	THE DOCUMENT IN THE DESCRIPTION OF THE DOCUMENT OF THE DOCUMEN		

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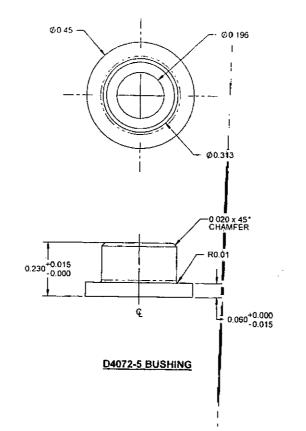
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NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC, M303B
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC.			
DRAWN	RF				
CHÉCKED	-#-	DRAWING NO.	REV. B		
MFG. APPR.	91	D4072	SHEET 3 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.	#	AIRFRAME HINGE	NTS		
DATE 10.11.02		COPYRIGHT © 2010 BY DART AEROSPACE USA, NC. https://document.com/districtions/com/districti			

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